

**Work Order ID 80046**

Thursday, February 09, 2012 11:21:16 AM

**\*80046\***

Page 1

Item ID: D4055-11

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tank Front and Bottom

Start Date: 2/10/2012 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 2/24/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

*mk*Date: *12-02-09* Tooling:

Date:

Run Start **\*NR1\***

QC:

Date: SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

0.00

**\*100\***

Purchasing

Memo

0.00

Purchasing

Issue P/O: *16157*  
Purchase part as per Dwg D4055  
Possible Supplier: GFI  
Material release note required*12-02-7*  
*4*

110

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

*614318* *E*

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

*812/63/06**(24)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\*NOTE: Date & initial all entries

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Revision ID:

Item Name: Tank Front and Bottom

Stop

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Start Date: 2/10/2012 Start Qty: 4.00

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Required Date: 2/24/2012 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00

**\*130\***

HandFinish

Memo

0.00

Hand Finishing

*4X JMF 12/03/06*

140

QC3- Inspect Part Finish

0.00

**\*140\***

QC

Memo

0.00

Quality Control

*H AK 12-3-6*

150

Identify as per dwg & Stock Location: *W1A*

0.00

**\*150\***

Packaging

Memo

0.00

Packaging

*12-03-09 4 0*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/3/12

217-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

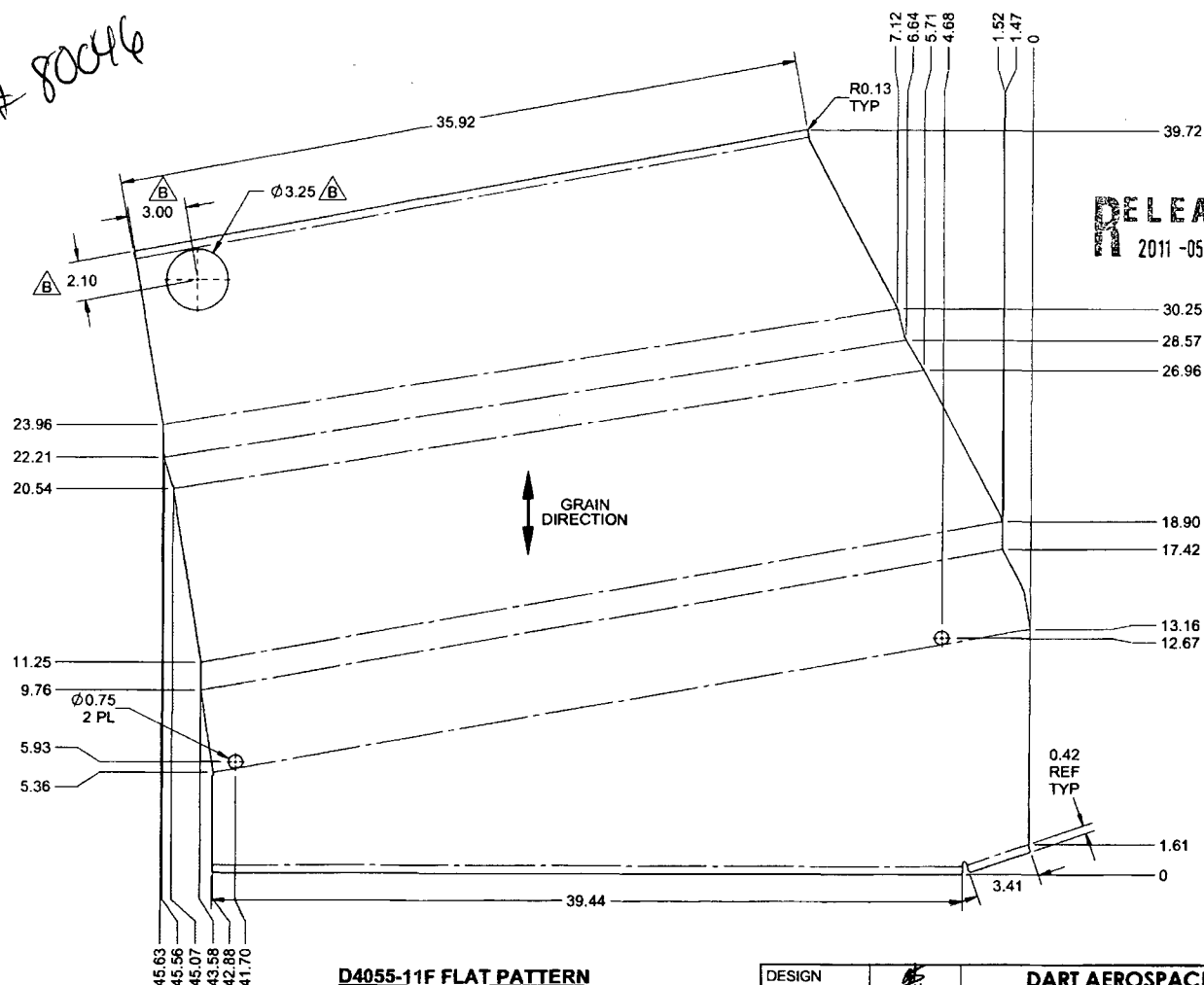
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# 80046

RELEASED  
2011-05-30



**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.32 lbs

**D4055-11F FLAT PATTERN**

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 15 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

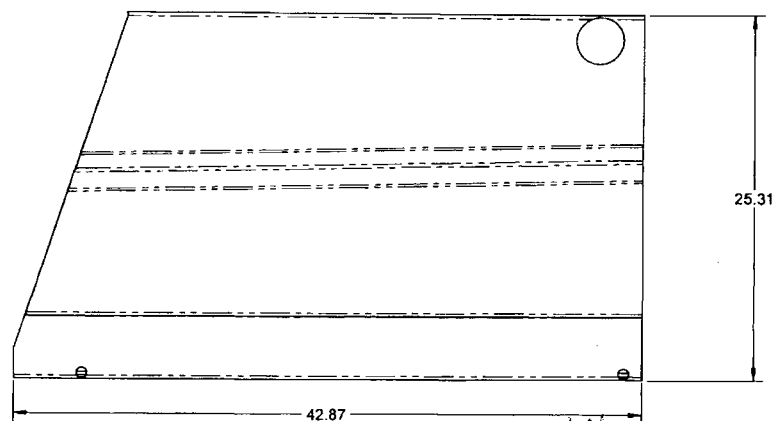
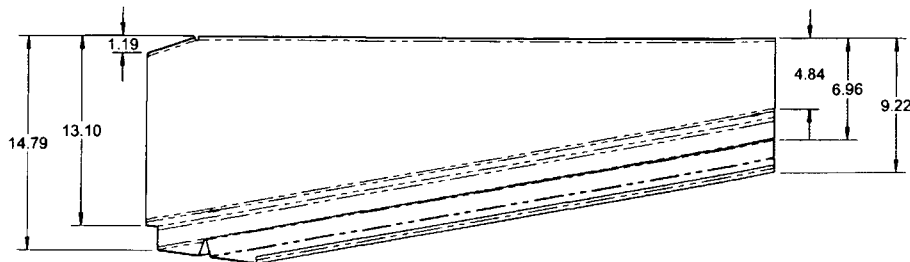
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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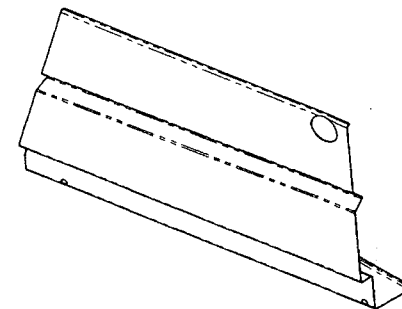
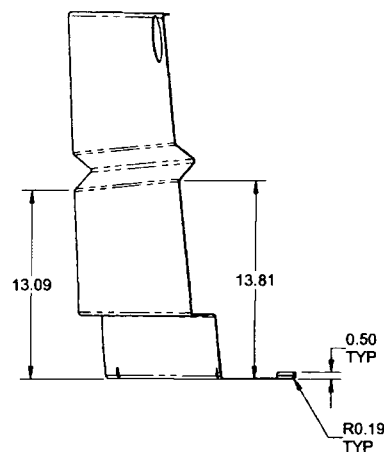
**NOTE:** Date & initial all entries





# 80046

**D4055-11 TANK FRONT AND BOTTOM**



- NOTES:
- 1) MATERIAL: MADE FROM D4055-11F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 9.32 lbs



DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 14 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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**RELEASED**  
2011-05-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO16157**

Purchase Order Date 2/9/2012

PO Print Date 2/9/2012

Page Number 1 of 1

**Order From :**

VC-GFI001

GFI  
180 AVENUE LABROSSE  
POINTE CLAIRE, QC H9R 1A1  
CA

**Contact Name**

**Vendor Phone**

514 630 4877

**Vendor Fax**

514 630 4849

**Vendor Account Nbr**

**Buyer**

Brigitte Golden

**Requisition Nbr**

**Tax Resale Nbr**

10127-2607

**Terms**

Net 30

**Currency**

CAD

**FOB**

Destination-Collect

**Ship To :**

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D4055-9P	Tank Back	2/14/2012 Yes	4.00 Each	FedEx Overnigh	\$115.0000	\$460.00
		<b>Special Inst:</b>	As per DWG: D4055 Rev: B B80045				
2	D4055-11P	Tank Front and Bottom	2/14/2012 Yes	4.00 Each	FedEx Overnigh	\$115.0000	\$460.00
		<b>Special Inst:</b>	Same as above B80046				
3	D4055-5P	Tank Upper Cut Out	2/14/2012 Yes	4.00 Each	FedEx Overnigh	\$115.0000	\$460.00
		<b>Special Inst:</b>	Same as above B80047				

**PO Total:**

**\$1,380.00**

Change Nbr: 1

Change Date: 2/9/2012

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable



180 AVENUE LABROSSE  
POINTE-CLAIRE, QC, CANADA H9R 1A1  
TÉL.:(514) 630-4877 - FAX:(514) 630-4849

GFI est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

VENDU À / SOLD TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7



# BON DE LIVRAISON / SHIPPING MEMO

DATE DE LIVRAISON / SHIPPING DATE			N° DE BON DE LIVRAISON / SHIPPING MEMO NO		PAGE
JR - DY	MO - MO	AN - YR			
02	03	12	0482084		1/1

EXPÉDIÉ À / SHIP TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON  
K6A 1K7



CODE DE CLIENT / CUSTOMER CODE		N° DE CONTRAT / JOB NO	VOTRE N° DE COMMANDE / YOUR PURCHASE ORDER NO	EXPÉDIÉ PAR / SHIP VIA			
DART GFI-0299		0245062	PO16157				
QUANTITÉ / QUANTITY	N° DE PIÈCE / PART NO			DESCRIPTION			
4	D4055-11P			TANK FRONT AND BOTTOM CERTIFICATE OF CONFORMANCE REQ			
MFG. JOB# <u>J0245062-001</u> QTY <u>4</u>							

REÇU PAR / RECEIVED BY

EXPÉDITEUR / SHIPPER

N° DE BON DE LIVRAISON / SHIPPING MEMO NO

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO. <u>8</u>		OUR JOB NO <u>J0245062</u>		SHIPPING MEMO <u>0482084</u>	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME
<u>-</u>	<u>4 PCS</u>	<u>PO16157</u>	<u>D4055-11P</u>	<u>B</u>	<u>TANK FRONT AND BOTTOM</u>
MATERIAL		SUPPLIED BY		MAT. REL. NO.	
<u>.063 THK AL 6061-T6 (AMS-QQ-A250/11)</u>		<u>SAMUEL / ALCOA INC</u>		<u>776794</u>	
PROCESS			PROCESSOR	RELEASE NOTE #	
<u>FIRST ARTICLE INSPECTION REPORT ON FILE</u>			<u>GFI</u>	<u>N/A</u>	
1	<u>REF. GFI MANUFACTURING JOB NUMBER J0245062-001 (4 PCS)</u>				
2					
3					
4					
5					
6					
7					
8					
9					

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 02 MARCH 2012

G.F.I. Q.C. REP.

BSamer





Programme d'Assurance Qualité Enregistré / Registered Q.A. Program  
ISO 9001:2008 + AS9120A

### LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Date: January 25, 2012

Company Name: GFI Division of Thomas & Betts limited  
Address: 180 avenue Labrosse  
City: Pointe-Claire, Qc  
Zip Code: H9R 1A1

# du client: 0080135  
Customer's order #:

# de commande SSMQ: 223675  
SSMQ's Order #:

La présente est pour certifier que le matériel détaillé ci-dessous est conforme aux exigences de votre commande et des normes du grade tel que décrit:

The following is to certify that the material listed below meets your order requirements and grade standards as described:

Notre/Our Item #	# de pièces/ # of pieces	Épaisseur/Grandeur Guage/Size	Alliage/Trempe Alloy/Temper	Spécification / Specification	Lot/Heat
01	2	.0630" X 48" X 144"	6061 T6	AMS-QQ-A-250/11 AMS 4027	776794

Bien à vous,  
Yours truly,



# CERTIFIED INSPECTION REPORT

Alcoa Inc.

DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per

Malcolm Murphy

Director of Manufacturing Davenport Works

Terrence Thom

Quality Assurance Manager

1310855

0

Ship Date

B.L. No.

Invoice No.

Alcoa No. Item

2011-11-15

6502263

00000

1000315959-1

DCE-15959-1

P.O. No./Govt Contract No.

Custom

Alcoa Item

C64168 Ln#: 1

SAMUEL SON & CO LT G041094947R06

Page 1 of 2

Ship To: SAMUEL SON & CO LTD  
S.S.M.Q  
21525 CLARKE-GRAHAM  
BAIE D'URFE H9X 3T5 QC

## Item Description

0.063 IN TK (+0.0000 -.0035) X 48.0 IN W (+.125 -  
.125) X 144.0 IN LN (+.15625 -.15625) (N) A/T 6061-  
T6 FLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EXC\_MRK  
ASTMB209 REV 10 CMMPO25 REV S ((MARKED))  
KRAFT PAPER INTERLEAVED  
MAX GROSS SKID WGT: 4500 LB QUAN TOL +/-  
30 % CQR 0210640 REV 06 CUST REQ 11-11-  
05 \*\*\* W/E 11-11-19 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	355202	776794	4012	100	PC	27809 47346 D239183
2	355203	776794	4062	100	PC	27809 47346 D239184
3	355205	776794	4018	100	PC	27809 47346 D239185
			12092	300		

Notes for CQR: 0210640.6

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0210640.6 -Specification Limits -----

Uts	TYS	EL4D
KSI	KSI	PCT
Max		
Min	42.0	35.0
		10



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P.O. No./Govt Contract No.

Customer

Alcoa Item

C64168 Ln#: 1

SAMUEL SON & CO LT G041094947R06

Page 2 of 2

CQR: 0210640.6 -Specification Limits (cont.)

Chemical Composition		SI	FE	CU	MN	MG	CR	ZN	TI	Other Each	Other Total	Aluminum
Alloy	6061	Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15
Lot:	776794	Min	0.40		0.15		0.8	0.04				

- Mechanical, Physical, Metallography, Quantometer Results

Temp	Dir	No->	UTS	TYS	EL4D
T6	Long Transv.	Test	KSI	KSI	PCT
		2	51.3	45.3	11
			51.2	45.3	11

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
11R04174	Actuals	0.65	0.5	0.25	0.03	1.0	0.16	0.01	0.05

This material was melted in the United States or a Qualifying Country [REF DFARS 225.872.1(a)]; it was manufactured in the United States

